

Work Order ID 61925-2
Thursday, September 09, 2010 12:54:33 PM

~~PRELIMINARY ISSUE~~ 10.10.01

Item ID: D4180-3
Revision ID: PRELIM
Item Name: Gusset
Start Date: 9/9/2010
Required Date: 9/16/2010
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date: 10-9-09
Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description
Draw Nbr	Revision Nbr
D4180	PA1

100
Waterjet
FLOW CNC Waterjet

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

0.00

0.00

10-4-13

14

Memo
1-Cut as per Dwg
Dwg Rev: PA1
Prog Rev: PA1

2-Debur if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-4-13

110
QC
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61925

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Page 2

Item ID: D4180-3

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 - 8/10/09/13

0.00

inspected to PA
Dry only

(24)

130



Brake NC

Brake NC

Bend as per dwg

Memo

0.00

0.00

8/10/09/14

(4)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 - inspected to PA

0.00

Dry only

8/10/09/14 (24)
-3

W/O:		WORK ORDER CHANGES					
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Work Order ID 61925

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Page 3

Item ID: D4180-3
Revision ID: PRELIM
Item Name: Gusset

Accept



Setup Start



Stop



Start Date: 9/9/2010 Start Qty: 2.00



Required Date: 9/16/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

7H 10/09/10

4 0

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10 9-16

(4) 0

170



Packaging

Packaging

Identify as per dwg & Stock Location: CA

Memo

0.00

0.00

Ian

2T 10-10-01 (Y3)

W/O:		WORK ORDER CHANGES					
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Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/10/04

POSITIVE RECALL

EFFECTIVE 10.10.09 AUTH h

RELEASED h DATE 10.10.01

PRE RELEASED DUE
DATE 10.04.09

PS10-10-01
③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 12:54:38 PM

Page 1

Work Order ID: 61925

Parent Item: D4180-3

Parent Item Name: Gusset




Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	125.2600	0.114	0.24			



1810-4 13

Location

Loc Qty

Loc Code

MAT21

125.26

113608

96

114352

29.26

114352

(4)

W/O:		WORK ORDER CHANGES					
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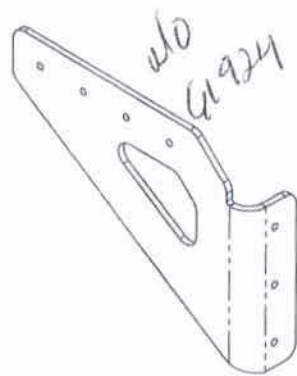
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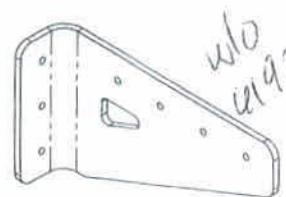
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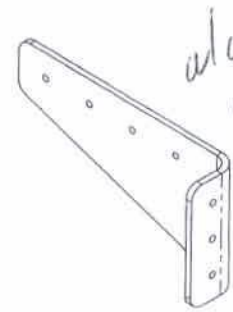
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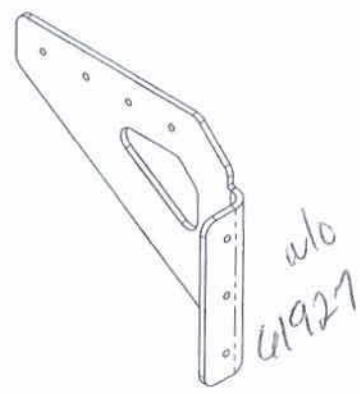
D4180-1 GUSSET



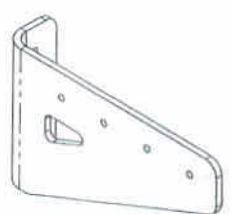
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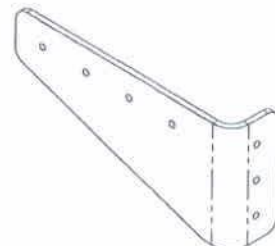
D4180-5 GUSSET



D4180-2 GUSSET



D4180-4 GUSSET



D4180-6 GUSSET

41925
P/10-9-09

PRELIMINARY ISSUE
10.09.08

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4180	REV. PA1 SHEET 1 OF 4
TITLE POD FRAME GUSSETS	SCALE NTS
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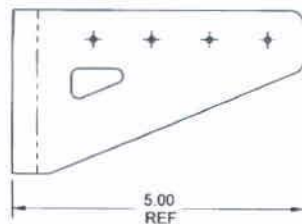
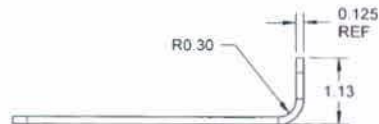
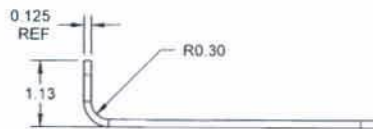
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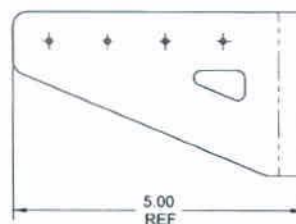
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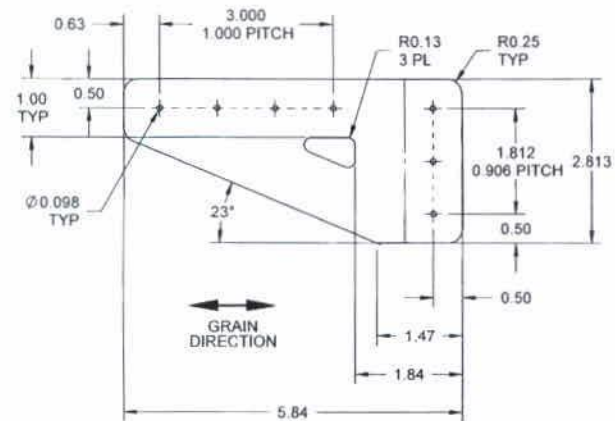
NOTE: Date & initial all entries



D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



D4180-3F GUSSET FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG APPR		D4180	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR		POD FRAME GUSSETS	NTS
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RELEASED
2010-09-29

61925